

Date: Thursday, 23/04/2009 3:30:28 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ASSY (RH)
Job Number : 47439	
Estimate Number : 13286	
P.O. Number :	Part Number : D3699042
This Issue : 23/04/2009 S.O. No. :	Drawing Number : D3699 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 44851	Material :
Written By :	Due Date : 10/05/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.04.24</u>	
Comment : Est Rev:A 08-04-25 new issue DD verified by:ec Est Rev:B 08-07-14 revA as per dwg DD verified by:ec	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S050	6061-T6 .050 Sheet
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Comment: Qty.: 0.4797 sf(s)/Unit Total : 4.7975 sf(s)
 6061T6 aluminium sheet .050" thick
 (M6061T6S050)
 Batch: 116791 B 9-5-26

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3699
 Dwg Rev: A B 9-5-26
 Prog Rev: A
 ***grain direction along 9.00" ***
 2- Deburr if necessary B 9-5-26



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

507/05/26 (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Bend as per Dwg D3697

SR 09/05/26 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:28 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 47439

Part Number: D3699042

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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(-2)

Comment: INSPECT WORK TO CURRENT STEP

09/05/26 (X12)

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- counter sink holes as per dwg D3699

8.0	QC5	INSPECT WORK TO CURRENT STEP
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(-2)

Comment: INSPECT WORK TO CURRENT STEP

09/05/27 (12)
09/05/27 (X12)

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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(12)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UMP 09/05/27

10.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME: 3:15pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 3:45pm

09-05-27 (X12)

11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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(12)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/05/28

12.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

13.0	MS21059L3	Nut Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Nut Plate

batch: M109962

09/05/28 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 23/04/2009 3:30:28 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSY (RH)

Job Number: 47439

Part Number: D3699042

Job Number:



Seq. #: Machine Or Operation: Description :

14.0 MS20426AD33 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Rivet

batch: 7681

9/5/28 (12)

15.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg D3699

09/05/28 (2)

16.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/05/28 (42)

17.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 255

09/05/28 (X12)

18.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/28

Job Completion



ME
09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 47439
Description: Support, RH		Part Number: D3699-2
Inspection Dwg: D3699	Rev: A	Page 1 of 1

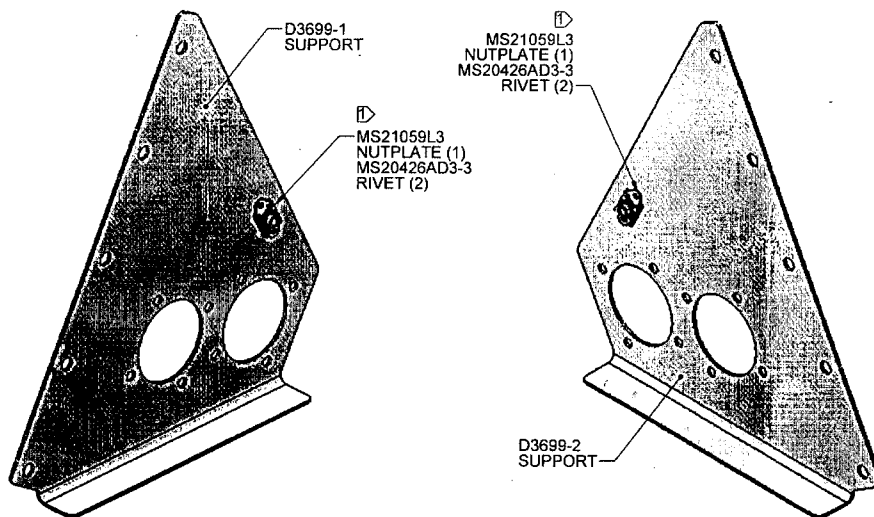
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.099	X			
Ø0.180	+0.005/-0.001	.181	X			
Ø0.238	+0.005/-0.001	.240	X			
Ø1.525	+0.012/-0.001	1.524	X			
0.36	+/-0.030	.361	X			
0.62	+/-0.030	.621	X			
0.96	+/-0.030	.964	X			
2.21	+/-0.030	2.212	X			
4.12	+/-0.030	4.121	X			
8.95	+/-0.030	8.953	X			
1.925	+/-0.010	1.922	X			
8.61	+/-0.030	8.618	X			
2.62	+/-0.030	2.620	X			
0.344	+/-0.010	.344	X			
0.688	+/-0.010	.686	X			
0.64	+/-0.030	.64	X			
2.66	+/-0.030	2.661	X			
5.75	+/-0.030	5.749	X			
6.41	+/-0.030	6.396	X			
0.300	+/-0.010	.300	X			
0.923	+/-0.010	.923	X			
0.050	+/-0.010	.049	X			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-5-26	Date: 09/05/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DD	



PART LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3699-041	SUPPORT ASSEMBLY
	X	D3699-042	SUPPORT ASSEMBLY
1		D3699-1	SUPPORT
	1	D3699-2	SUPPORT
1	1	MS21059L3	NUTPLATE
2	2	MS20426AD3-3	RIVET

D3699-041 SUPPORT ASSEMBLY

D3699-042 SUPPORT ASSEMBLY

RELEASED
08.07.12

- NOTES:
- 1) INSTALL MS21059L3 NUTPLATE USING C/SINK $\phi 0.098$ HOLES ON D3699-1/-2
 - 2) IDENTIFICATION: IDENTIFY WITH DART ASSEMBLY P/N D3699-041/-042 & B/N USING FINE POINT PERMANENT INK MARKER
 - 3) WEIGHT: 0.17 lb EACH

A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

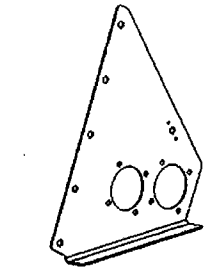
DRAWING NO. **D3699**

TITLE **SUPPORT ASSEMBLY**

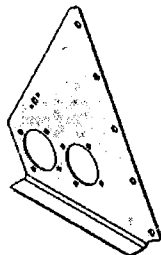
REV. A
SHEET 1 OF 2
SCALE
NTS

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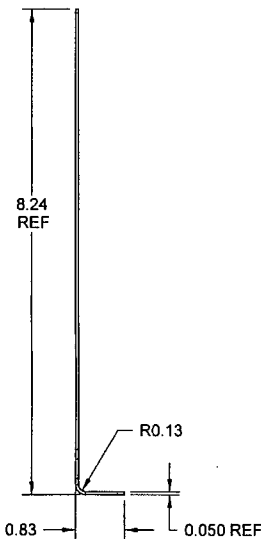
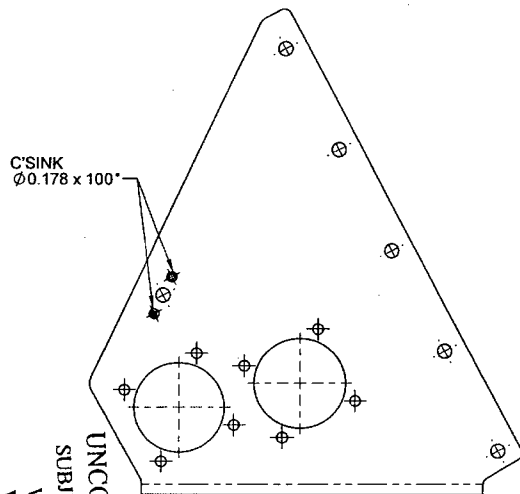
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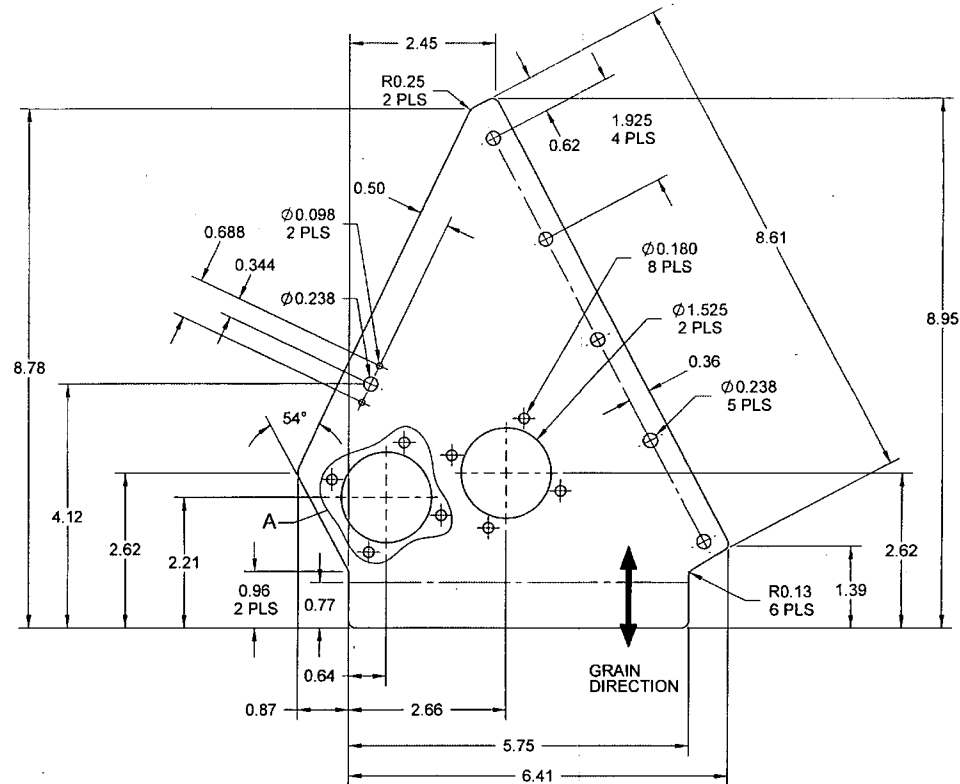
D3699-1 LH SUPPORT



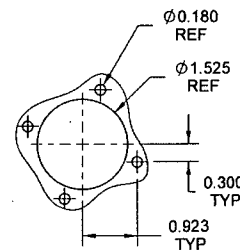
D3699-2 RH SUPPORT



**D3699-1 SUPPORT, LH SHOWN
(D3699-2 SUPPORT, RH OPPOSITE)
(MAKE FROM D3699-1F FLAT PATTERN)**



D3699-1F FLAT PATTERN



DETAIL A

RELEASED
08-07-08

- NOTES:
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M2024T3S.050 OR M6061T6S.050)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.17 lbs

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3699	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE SUPPORT ASSEMBLY	SCALE NTS
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